

Work Order ID 77661

Wednesday, December 14, 2011 10:49:36 A

Page 1

180 AND \*77661\*

Item ID: D412-698-023

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Automatic Door Opener, LH/RH

Start Date: 12/14/2011 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 1/6/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan:

*R*

Date: 12/14 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
IIN D412-698	Rev E								
100 <b>*100*</b> DC Document Control	DOCUMENT CONTROL Memo Photocopy bluefile & type labels per PPP D412-698-023	0.00		CHG002	S.12.11.17				<i>MLJ 12-1-17</i>
110 <b>*110*</b> Packaging Packaging	Pick Kit Memo	0.00							<i>12/11/17 (8)</i>
120 <b>*120*</b> QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00			S.12.11.17				<i>(46)</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

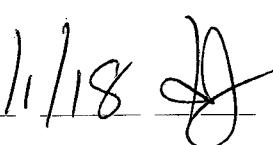
NOTE: Date & initial all entries

**Work Order ID** 77661**\*77661\***

Page 2

Wednesday, December 14, 2011 10:49:36 A

**Item ID:** D412-698-023**Accept****\*N900040100\*****Setup****Start****\*NS1\*****Revision ID:****Item Name:** Automatic Door Opener, LH/RH**Stop****\*NS2\*****Start Date:** 12/14/2011 **Start Qty:** 6.00**\*6\*****Cust Item ID:****Required Date:** 1/6/2012 **Req'd Qty:** 6.00**\*6\*****Customer:****Reference:****Approvals:** **Process Plan:** \_\_\_\_\_**Date:** \_\_\_\_\_**Tooling:** \_\_\_\_\_**Date:** \_\_\_\_\_**Run****Start****\*NR1\*****QC:** \_\_\_\_\_**Date:** \_\_\_\_\_**SPC (Y/N):** \_\_\_\_\_**Date:** \_\_\_\_\_**Stop****\*NR2\***

<b>Sequence ID/ Work Center ID</b>	<b>Operation Description</b>	<b>Set Up/ Run Hours</b>	<b>Tool ID</b>	<b>Tool #</b>	<b>Plan Code</b>	<b>Accept Qty</b>	<b>Reject Qty</b>	<b>Reject Number</b>	<b>Insp. Stamp</b>
130 <b>*130*</b> Packaging	Packaging	0.00						12/1/17	
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D412-698-023								
	Location: <u>10</u>								
	PPP Rev: <u>B</u>								
140 <b>*140*</b> QC	QC21- Final Inspection - Work Order Release	0.00						12/1/18	
Quality Control	Memo	0.00						UMS	
								12-01-17	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, December 14, 2011 10:49:42 AM

Work Order ID: 77661

\*77661\*  
\*D412-698-023\*

Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 12/14/2011

Required Date: 1/6/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-12 JLM  
IPP rev B ecn 1207 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN960JD516L	NAS1149D0516J	Purchased	No			120	Each	0.0000	2	12			
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**\*AN960.ID516I \***

Washer

D3552-11

**\*D3552-11\***

Door Prop

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN960JD516L	NAS1149D0516J	Purchased	No			120	Each	0.0000	2	12			
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D3552-11		Manufactured	No			120	Each	25.0000	1	6			
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**\*D3552-11\***

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3552-11		Manufactured	No			120	Each	25.0000	1	6			
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**\*D3552-11\***

D3594-043		Manufactured	No			120	Each	15.0000	1	6			
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D3594-043		Manufactured	No			120	Each	15.0000	1	6			
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**\*D3594-043\***

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3594-043		Manufactured	No			120	Each	15.0000	1	6			
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**\*D3594-043\***

D3594-044		Manufactured	No			120	Each	14.0000	1	6			
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D3594-044		Manufactured	No			120	Each	14.0000	1	6			
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**\*D3594-044\***

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3594-044		Manufactured	No			120	Each	14.0000	1	6			
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**\*D3594-044\***

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

Page 2

Wednesday, December 14, 2011 10:49:42 AM

Work Order ID: 77661

**\*77661\***  
**\*D412-698-023\***

Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 12/14/2011

Required Date: 1/6/2012

Start Qty: 6.00

Required Qty: 6.00

D3594-5

Manufactured No

120

Each

21.0000

1

6

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**\*D3594-5\***

Door Doubler

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST234A	21	
	21	

76098

D3622-1

Manufactured No

120

Each

38.0000

2

26098

12

\*\*

**\*D3622-1\***

Ball Stud

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST070	38	
	38	

76889

MS20426AD4-4

Purchased No

120

Each

1,417.000

2

26889

12

\*\*

**\*MS20426AD4-4\***

Rivet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST317	1417	
	1417	

116188

MS21073L5

Purchased No

120

Each

62.0000

1

116188

6

\*\*

**\*MS21073L5\***

nut plate

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST302	62	
	62	

117395

117395

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS**

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Date: 08.05.01